



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4893-1
Job Sheet 177136



Part No: D4893-1

Job Qty: 4 ea

Part Name: Hard Point Adapter, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/7/18

Job Tracking No:

Due Date: 6/8/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-05-27 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	4 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Machining-3		DAS
100	Bandsaw	4 pcs	6/8/18	6/8/18	0.00	0.00	Bandsaw1		54
110	CNC Vertical Machining	4 pcs	6/8/18	6/8/18	0.24	5.33	HAAS1-5		9-89
130	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC8 Machining-3		SA 18-06-07
140	HandFinish	4 pcs	6/8/18	6/8/18	0.00	0.39	HandFinish1		SA 18-06-07
150	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC7-4		SA 18-06-07
151	Powdercoat	4 pcs	6/8/18	6/8/18	0.00	0.17	Powdercoat1		SA 18-06-07
155	QC	4 pcs	6/8/18	6/8/18	0.00	0.00	QC3		SA 18-06-07
170	Packaging	4 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-2		SA 18-06-07
180	QC21-SA	4 Ea	6/8/18	6/8/18	0.00	0.00	QC21		SA 18-06-07

Part Op 100 - Cut blank:3.375" long

Descriptions: 110 - 1- Machine as per Folio FB193 and Dwg D4893

151 - MASK AS PER NOTE 9

M138839 START: 12:55 QUIT: 3:20 FINISH: 1:25

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X05.000	6061T6 Bar 2.00 X 5.000	1.1600 ft (.29 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X05.000	1	12	0

DART
AEROSPACE

Container No: S078296



Part: D4893-1

Job No: 177136

Serial No/Batch: S078296

Revision:

Inspector:

Exp Date: 06/05/2018

Instructions:

1210 ADRIAN STREET
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/05/18

AC
JP

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Hardpoint Adaptr, LH	72.000Degrees ± 0.500	72.500 71.500	Angle	
2	Hardpoint Adaptr, LH	1.500Inches ± 0.030	1.530 1.470	1.499	
3	Hardpoint Adaptr, LH	0.030Inches ± 0.030	0.060 0.000	.060	
4	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500	Angle 45°	
5	Hardpoint Adaptr, LH	2.450Inches ± 0.030	2.480 2.420	2.448	
6	Hardpoint Adaptr, LH	1.300Inches ± 0.030	1.330 1.270	1.299	
7	Hardpoint Adaptr, LH	0.750Inches ± 0.030	0.780 0.720	0.745	
8	Hardpoint Adaptr, LH	2.500Inches ± 0.030	2.530 2.470	2.506	
9	Hardpoint Adaptr, LH	1.250Inches ± 0.030	1.280 1.220	1.258	
10	Hardpoint Adaptr, LH	0.250Inches ± 0.030	0.280 0.220	Radius .250	
11	Hardpoint Adaptr, LH	0.500Inches ± 0.030	0.530 0.470	.495	
12	Hardpoint Adaptr, LH	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter .137	
13	Hardpoint Adaptr, LH	0.204Inches + 0.005 - 0.001	0.209 0.203	Diameter .205	
14	Hardpoint Adaptr, LH	1.500Inches ± 0.030	1.530 1.470	1.497	
15	Hardpoint Adaptr, LH	1.000Inches ± 0.030	1.030 0.970	1.020	
16	Hardpoint Adaptr, LH	1.000Inches ± 0.030	1.030 0.970	.997	
17	Hardpoint Adaptr, LH	0.130Inches ± 0.030	0.160 0.100	Radius .130	
18	Hardpoint Adaptr, LH	0.830Inches ± 0.030	0.860 0.800	.825	
19	Hardpoint Adaptr, LH	0.100Inches ± 0.030	0.130 0.070	.095	
20	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500	Angle 45°	
21	Hardpoint Adaptr, LH	1.750Inches ± 0.030	1.780 1.720	1.750	
22	Hardpoint Adaptr, LH	1.460Inches ± 0.030	1.490 1.430	1.466	
23	Hardpoint Adaptr, LH	1.650Inches ± 0.030	1.680 1.620	1.649	
24	Hardpoint Adaptr, LH	4.000Inches ± 0.030	4.030 3.970	3.998	
25	Hardpoint Adaptr, LH	0.250Inches ± 0.030	0.280 0.220	.250	
26	Hardpoint Adaptr, LH	45.000Degrees ± 0.500	45.500 44.500	Angle 45°	
27	Hardpoint Adaptr, LH	0.750Inches ± 0.010	0.760 0.740	.743	
28	Hardpoint Adaptr, LH	1.015Inches ± 0.010	1.025 1.005	Diameter 1.021	